

**\*123242\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 8/01/14      **Start Qty:** 20.00

**\*20\***

**Cust Item ID:**

**Required Date:** 8/14/14      **Req'd Qty:** 20.00

\*20\*

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.3900	C

100

0.00

**\*100\***

## BAND SAW

Bandsaw

## Memo

0.00

## Jeaspa Bandsaw

Cut Blank at 20,000"

\*\*\* ONE BLANK MAKES TWO PARTS \*\*\*

**DAS**  
**44**  
**9-89**

14/08/05

110

0.00

**\*110\***

## HAAS CNC VERTICAL MACHINING #1

HAAS 1

# Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB309

DWG REV:

FOLIO REV

FOLIO REV

2- deburr and break all sharp edges

# Work Order ID 123242

August-01-14 10:59:31 AM

**\*123242\***

Page 2

Item ID: 647.3912 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Lower Deflector  
 Start Date: 8/01/14 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 8/14/14 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
<b>*140*</b>									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>25477</u>								
	1- Black Anodize as per Dwg 647.3900								
	2- PRIME AS PER DWG, SEE NOTE #9								
	Certification of Comformity is required								

# Work Order ID 123242

\*123242\*

Page 3

Item ID: 647.3912 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Lower Deflector  
 Start Date: 8/01/14 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 8/14/14 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
*150*									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
*155*									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <i>ME3</i>	0.00							
*180*									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								

*8/14/14* *(18)*

*16* *DAS 38 9-89 14-5*

*16x* *SPC 4-9-5*

**Work Order ID 123242****\*123242\***

Page 4

Item ID: 647.3912

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Lower Deflector

Stop **\*NS2\***

Start Date: 8/01/14 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 8/14/14 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

MLJ 14-09-08*MF*  
*14-9-05*

# Picklist Print

August-01-14 10:59:31 AM

Page 1

Work Order ID: 123242

\*123242\*

Parent Item: 647.3912

\*647 3912\*

Parent Item Name: Lower Deflector

Start Date: 8/01/14

Required Date: 8/14/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV.A NEW ISSUE JFS 14/05/29 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B0.375X6.000		Purchased	No			100	f	22.5209	0.834	18			

\*M7075T6B0 375X6 000\*

7075-T6 BAR 0.375" X 6.000"

\*\*

Location

Loc Qty

Loc Code

MAT049

22.5209

M128038

4.2167

• M129891

18.3042

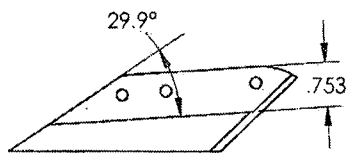
18.30421

DAS

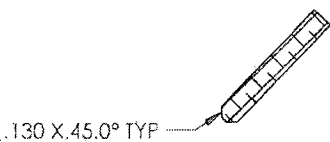
44  
9-89

14/08/07

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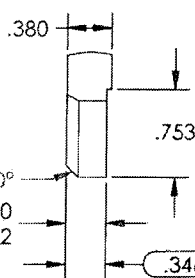


SECTION L-L

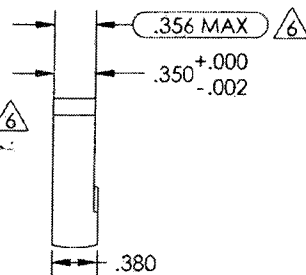


SECTION M-M

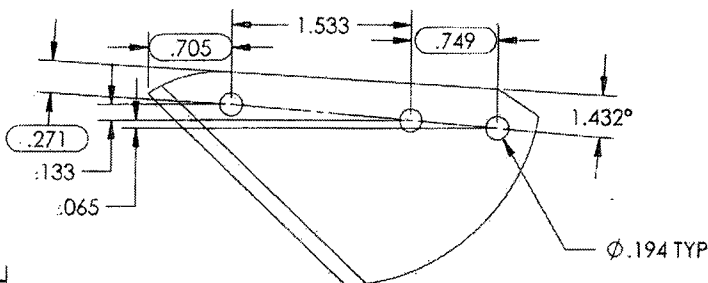
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.340<sup>+0.000</sup>  
-.002



DETAIL J  
Ø.177



DETAIL K

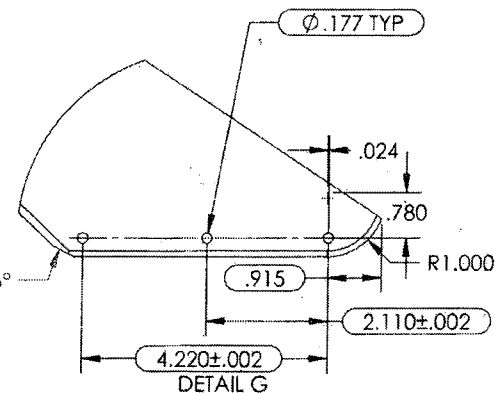
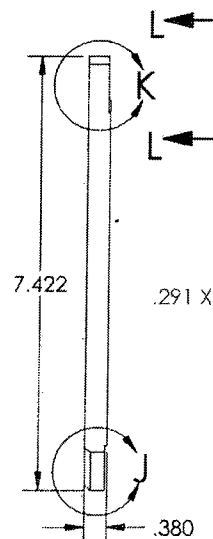
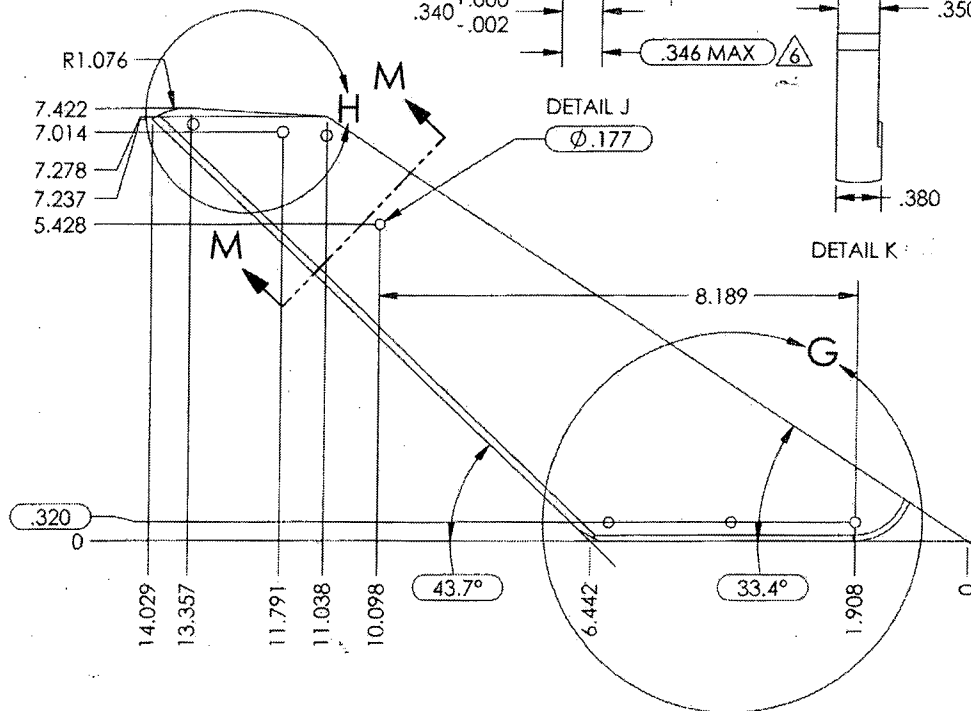


DETAIL H



647.3912

123242



ORIGINAL DATE 10/20/2011 09:10:09		APICAL INDUSTRIES	
DRAWN BY J. SCHUBERT		2608 TEMPLE HEIGHTS DR.	
CHECKED BY J. SCHUBERT		OCEANSIDE, CA 92056-3512 (760)724-5300	
DRAWING APPROVAL P. B. V. O.		DEFLECTORS	
CONTRACT NO.		647.3900	
UNITS: GOVERNMENT SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SCALE: NONE	SHEET 4 OF 12

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	123242
<b>Description:</b> DEFLECTORS	<b>Part Number:</b>	647.3912
<b>Inspection Dwg:</b> 647.3900 Rev: C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.9°	± 1/2°	30°	✓		C-Agum	
.753	±.005	.753	✓		Vern	ML-06
.130X45°	±.005 X ± 1/2°	.125X45°	✓		"	
.380	±.005	.385	✓		"	
.753	±.005	.754	✓		"	
.340	±.002	.3382	✓		Micr	ML-01
.100X45°	±.005 X ± 1/2°	.105X45°	✓		Vern	ML-06
.350	±.002	.348	✓		Micr	ML-01
.271	±.005	.271	✓		Vern	ML-06
.705	±.005	.700	✓		H-G	31006
1.533	±.005	1.535	✓		"	
.749	±.005	.749	✓		"	
8.194	±.005	8.193	✓		Vern	ML-06
.065	±.005	.065	✓		H-G	31006
.133	±.005	.133	✓		"	"
7.422	±.005	7.423	✓		"	
8.177	±.005	8.177	✓		Vern	ML-06
.915	±.005	.918	✓		"	
2.110	±.002	2.110	✓		"	
4.220	±.002	4.220	✓		"	
.320	±.005	.320	✓		"	
33.4°	± 1/2°	33.7°	✓		C-Agum	
43.7°	± 1/2°	43.7°	✓		"	

<b>Measured by:</b> <i>mf</i>	<b>Audited by:</b> DAS 44 9-89	<b>Preliminary Approval:</b>
<b>Date:</b> 14/08/16	<b>Date:</b> 14/08/18	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	=

10.04.15







Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO25477**

Purchase Order Date 8/21/2014

PO Print Date 9/2/2014

Page Number 4 of 4

**Order From :**

VC-ATG001

**Ship To :** DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.  
731 INDUSTRIELLE ROAD  
ROCKLAND, ON K4K 1T2  
CANADA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 613-446-4544

**Ship To Contact**

**Ship To Phone**

**Ship Via:** VENDOR'S TRUCK

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #** 10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

FCA - (Free Carrier)

9	123242	647.3912 LOWER DEFLECTOR (REV. C)	9/3/2014	16.00	\$11.45	\$183.20
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Yes

9/3/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

**Line Total:** \$183.20

10	71401-45	PROCUREMENT QUALITY CLAUSES	9/3/2014	1.00	\$0.00	\$0.00
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No

9/3/2014

**Procurement Quality Clauses**

A004 FAA-PMA /TSO

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A024 PROCESS CERTIFICATIONS

A025 CERTIFICATE OF CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

**Line Total:** \$0.00

**PO Total:** \$964.30

**Note:** Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

**Change Nbr:** 2

**Change Date:** 9/2/2014



A.T.G. Industries Inc.  
 731, rue Industrielle Rd.  
 PLATING DEPARTMENT  
 Rockland, On K4K 1T2  
 Canada  
 Ph: (613) 446-4544  
 Fax: (613) 446-4556

### Pack List

Number: 63235

Date: 02-Sep-14

#### To

DART AEROSPACE LTD  
 1270 ABERDEEN ST.  
 HAWKESBURY, ON K6A 1K7  
 Canada

#### Ship To

DART AEROSPACE LTD  
 1270 ABERDEEN ST.  
 HAWKESBURY, ON K6A 1K7  
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	Job: 20140558 PO: PO25477 Line:		
8 ea	Part: 647.0310 CHANNEL HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140559 PO: PO25477 Line:	Rev:	
6 ea	Part: 647.2113 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140560 PO: PO25477 Line:	Rev:	
6 ea	Part: 647.3910 UPPER DEFLECTOR HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140561 PO: PO25477 Line:	Rev:	
16 ea	Part: 647.3912 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140562 PO: PO25477 Line:	Rev:	
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			